

Work Order ID 127184

127184

gan5

Page 1

Monday, December 15, 2014 8:45:15 AM

Item ID: D3019-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Back Cushion
Start Date: 12/15/2014 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 12/31/2014 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: WKF Date: 14-12-15 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3019	B								

100	PURCHASING	0.00							CL 14/12/15 8
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100 Purchasing
Purchasing
Memo
Issue P/O: 26788
Possible supplier: Chestnut Ridge Airflex fire-resistant aircraft cushioning
Order: Grade 30-40 (colour green), Density 2.6lb/ft³
Material must meet FAR 27.853(a) or 25.853(a), Part is symmetric about centerline

110	Receive & Inspect for Damage & Mat'l Certs	0.00							8v 8015-01-5
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110 Packaging
Packaging
Memo
Ensure Material Release Note is attached

Work Order ID 127184

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Item ID: D3019-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Cushion

Start Date: 12/15/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/31/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

*****REMOVE "CHESTNUT FOAM" LABEL AND ATTACH TO WORK
ORDER FOR TRACEABILITY*****

JAN 08 2015

130

Identify as per dwg & Stock Location: ST415 0.00***130***

Packaging

Memo

0.00

Packaging

DAS
06
9-89

JAN 08 2015

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

MCS 15-01-09

15-18

Picklist Print

Monday, December 15, 2014 8:45:15 AM

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Work Order ID: 127184

127184

Parent Item: D3019-1

D3019-1

Parent Item Name: Back Cushion

Start Date: 12/15/2014**Required Date:** 12/31/2014

Start Qty: 8.00

Required Qty: 8.00

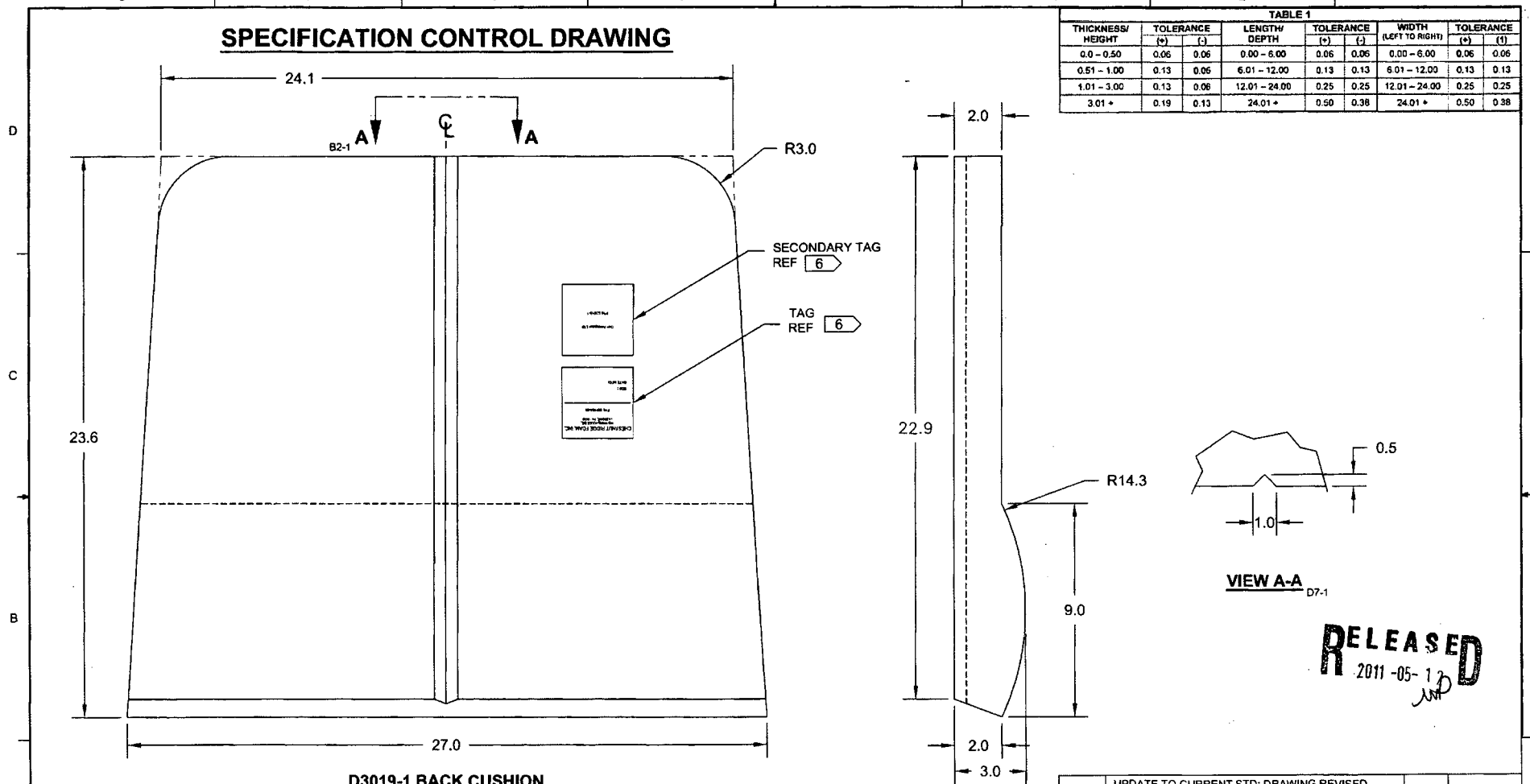
Comments: IPP: B01.06.07Removed acid etch & alodine EC/SM
11.08.08 added note per NCR 11-588 DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3019-1P		Purchased	No			110	Each	0.0000	1	8			
D3019-1P Back Cushion									**	<u>8x SP 15-01-5</u>			

SPECIFICATION CONTROL DRAWING

TABLE 1									
THICKNESS/ HEIGHT	TOLERANCE		LENGTH/ DEPTH	TOLERANCE		WIDTH (LEFT TO RIGHT)	TOLERANCE		
	(+)	(-)		(+)	(-)		(+)	(-)	
0.0 - 0.50	0.06	0.06	0.00 - 6.00	0.06	0.06	0.00 - 6.00	0.06	0.06	
0.51 - 1.00	0.13	0.06	6.01 - 12.00	0.13	0.13	6.01 - 12.00	0.13	0.13	
1.01 - 3.00	0.13	0.06	12.01 - 24.00	0.25	0.25	12.01 - 24.00	0.25	0.25	
3.01 +	0.19	0.13	24.01 +	0.50	0.38	24.01 +	0.50	0.38	



NOTES:

- 1) MATERIAL: MUST MEET FAR 27.853(a) OR 25.853(a)
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 30-40 (COLOUR GREEN)
DENSITY 2.6 lb/ft³
- 2) FINISH: NONE
- 3) TOLERANCES: PER TABLE 1
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

- 6) IDENTIFICATION: TAG(S), BURNED, TO SHOW THE FOLLOWING AT MINIMUM:
CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
SO#
DATE MFD:
DART AEROSPACE LTD. P/N D3019-1
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE
- 8) MAKE PER TEMPLATE
- 9) POSSIBLE SUPPLIER: CHESTNUT RIDGE P/N 601988-99

B	UPDATE TO CURRENT STD: DRAWING REVISED IAW CHESTNUT RIDGE MFG DWG. REF: NCR11-588	MB	11.05.10
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3019	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BACK CUSHION	NTS
DATE	11.05.10	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-05-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26788**

Purchase Order Date 12/15/2014

PO Print Date 12/15/2014

Page Number 1 of 2

Order From :

CHESTNUT RIDGE FOAM, INC.
PO BOX 6015
HERMITAGE, PA 16148
US

VU-CHE001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 724 537 9000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	D3018-1P AS PER DWG D3018 REV. B B127183	Seat Cushion	1/5/2015 Yes 1/5/2015		8.00 Each	\$60.40	\$483.
						Line Total:	\$483.
2	D3019-1P AS PER DWG D3019 REV. B B127184	Back Cushion	1/5/2015 Yes 1/5/2015		8.00 Each	\$46.77	\$374.
						Line Total:	\$374.

SP 1501-5

Note:

12/15/2014

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

Phone: 724-537-9000
Fax: 724-537-9003



Pack Slip: 64070

Packing Slip

Page: 1 of 1

Ship To: Fed Exp #1517-9324-0

Dart Aerospace Ltd.

1270 Aberdeen Street

Tel: 613-632-3336

Hawkesbury ONTARIO, CANADA K6A 1K7

Phone: 613-632-3336

Fax: 613-632-1053

Sold To: Chantal Lavoie Fax#: 613-632-1053

Dart Aerospace Ltd.

1270 Aberdeen Street

Tel: 613-632-3336

Hawkesbury ONTARIO, CANADA K6A 1K7

Phone: 613-632-3336

Fax: 613-632-1053

Ship Date: 12/31/2014

F.O.B. Origin

Ship Via: Fed Exp Int P1

PO Line	Part Number/Description	Planned Qty	Shipped Qty	Rev	PO Line
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Sales Order: 51502

Your PO: PO26788

Salesperson: Aircraft

Certificate of Conformity that all components comply with 14CFR 25.853(a) 12 Second Vertical Burn with Shipment

Line 1

Rel 1

D3018-1P

AIRFLEX Bottom Cushion

8.00 EA

8.00 EA

Our Part: 502148-99

Line 2

Rel 1

D3019-1P

AIRFLEX Back Cushion

8.00 EA

8.00 EA

Our Part: 601988-99

15-01-5

CONTACT CHESTNUT RIDGE FOAM IF THERE IS DAMAGE OR DISCREPANCIES 724-537-9000

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 15323
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF14016
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 55-65

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

CONDITIONING STARTED : DATE : 5-13-14
TIME : 12:00 PM

TEST STARTED : DATE : 5-14-14
TIME : 12:25 PM

RESULTS :

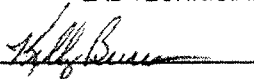
	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	5.2
#2.	0.0	0.0	5.2
#3.	0.0	0.0	4.8
AVG.	0.0	0.0	5.1

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853.
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : KELLY BURES
LAB TECHNICIAN



**CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 15384
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853**

PRODUCT: TICKING FR 4440 FABRIC
BATCH / LOT NO.: 0405
CUSTOMER: PRODUCTION
P.O. NO.:
OTHER IDENTIFICATION: SUPPLIED BY: HANES CONVERTING CO. OF CONOVER, NC
ON INVOICE #62-145425

TEST BEING RUN: VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F: YES

MATERIAL COMPOSITION: NA

MATERIAL PATTERN: WOVEN

MATERIAL COLOR: TAN

CONDITIONING STARTED: DATE: 6-19-14
TIME: 9:00 AM

TEST STARTED: DATE: 7-10-14
TIME: 1:30 PM

	FLAME TIME (SECONDS)		DRIPPINGS (SECONDS)		BURN LENGTH (INCHES)	
	WARP	FILL	WARP	FILL	WARP	FILL
#1.	0.0	0.0	0.0	0.0	4.0	3.9
#2.	0.0	0.0	0.0	0.0	4.0	3.9
#3.	0.0	0.0	0.0	0.0	3.9	3.6
AVG.	0.0	0.0	0.0	0.0	4.0	3.9

PASS: X FAIL:

COMMENTS:

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853, PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY: KELLY BURES
LAB TECHNICIAN

Kelly Bures

CONSIGNEE OFFICE 500 N. MCLENNAN CREEK RD. P.O. BOX 457 CONOVER, NC 28613-0457 PHONE (818) 464-4673 FAX (818) 464-0419				INVOICE RELEASE NAME FOR: HANES ENGINEERED MATERIALS L&P FINANCIAL SERVICES CO. P.O. BOX 60984 CHARLOTTE, NC 28260
SOLD TO CHESTNUT RIDGE FOAM ROUTE 981 NORTH PO BOX 781 LA TROBE, PA 15650		SHIP TO CHESTNUT RIDGE FOAM 443 WAREHOUSE DRIVE LA TROBE, PA 15650		
INVOICE NUMBER 62-145425	INVOICE DATE 6/13/2014	TERMS NET 30	CARRIER USF HOLLAND INC	ROUTING PER CUSTOMER REQUEST 5/17/01
CUSTOMER NO. 15985	CUSTOMER ORDER NO. 33660	BLS. NUMBER 65 452	ORDER DATE 6/10/2014	CONOVER, NC
PRODUCT NO. 10333		QUANTITY 40.000	DESCRIPTION TICKING FR 4440	PRICE 250.00
MATERIAL WARP		FLAME TIME 0.0	DRIPPINGS 0.0	BURN LENGTH 4.0
MATERIAL FILL		FLAME TIME 0.0	DRIPPINGS 0.0	BURN LENGTH 3.9
MATERIAL WARP		FLAME TIME 0.0	DRIPPINGS 0.0	BURN LENGTH 3.9
MATERIAL FILL		FLAME TIME 0.0	DRIPPINGS 0.0	BURN LENGTH 3.6
MATERIAL WARP		FLAME TIME 0.0	DRIPPINGS 0.0	BURN LENGTH 4.0
MATERIAL FILL		FLAME TIME 0.0	DRIPPINGS 0.0	BURN LENGTH 3.9
CERTIFICATION: THE SELLER DOES NOT CERTIFY, EITHER IMPLICITLY OR EXPLICITLY, THESE PRODUCTS TO MEET THE REQUIREMENTS OF ANY REGULATORY AGENCY OR SPECIFICATION EXCEPT AS MAY BE CERTIFIED ABOVE OR UNDER SEPARATE WRITTEN CERTIFICATION. ALL TRANSACTIONS ARE SUBJECT TO THE CONDITIONS ON THE REVERSE SIDE OF THIS INVOICE. USF HOLLAND INC PROD 10752083719				
RECEIVED JUN 23 2014 By _____				

15985 ORIGINAL 450 THE LAWS OF THE STATE OF NORTH CAROLINA SHALL GOVERN THIS TRANSACTION. A LATE PAYMENT CHARGE AT A PER ANNUAL RATE
 EQUAL TO THE PRIME RATE OF THE CHASE BARRINGTON BANK, N.A. IN EFFECT ON THE FIRST DAY OF EACH MONTH PLUS 1.0% PER ANNUUM
 WHICH RATE TO PRESENT WILL BE APPLIED TO THE PRINCIPAL OF EACH MONTH ON ALL PAID DUE ACCOUNTS DURING THE MONTH.

PAGE 1 LAST 41746



Chestnut Ridge
Foam, Inc.

Certificate of Conformance

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury
Ontario CANADA K6A 1K7

PURCHASE ORDER: PO26788

SALES ORDER: 51502

DATE SHIPPED: 12.31.2014

**"URGENT! FLAMMABILITY CERTIFICATION!
ENCLOSED. PLEASE FORWARD TO
PURCHASING. DO NOT THROW AWAY!"**

**I certify that the individual components comprising the part shipped
against the above-referenced purchase order meets the following
requirements:**

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	CRF Part Number	Material	Batch Number
8	D3018-1P	502148-99	Airflex 55-65	AF14016
8	D3019-1P	601988-99	Airflex 30-40	AF14038

MADE IN THE U.S.A

Grace Harr

Digitally signed by Grace Harr
DN: cn=Grace Harr, o=Chestnut Ridge Foam,
Inc., ou, email=grh@chestnutridgefoam.com,
c=US
Date: 2014.12.31 08:56:36 -0500

❖ 443 Warehouse Drive Latrobe, PA 15650
❖ Phone: 724-537-9000 Fax: 724-537-9003